

# Work Order ID 103163

June-18-13 8:22:53 AM

\*103163\*

Page 1

Item ID: D3204-11

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Plate

Start Date: 6/18/13 Start Qty: 30.00

\*30\*

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 30.00

\*30\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 6-18-13

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3204 Dwg Rev: A1 Prog Rev: A12  
Deburr if necessary

6061, 375" x 1.00"

30 0 Jm13-07-02

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

30 0 Jm13-07-02

120

CONVENTIONAL MILLING MACHINE

0.00

\*120\*

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Face to size .300" 2-Open hole to .191" as per Dwg D32043-Deburr

13-07-18

30 0

# Work Order ID 103163

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Page 2

Item ID: D3204-11

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Plate

Start Date: 6/18/13 Start Qty: 30.00 \*30\*

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 30.00 \*30\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
*130*									
QC	Memo	0.00		13-07-18		30	0		
Quality Control									
140	QC8- Inspect parts - second check	0.00							
*140*									
QC	Memo	0.00		B.A 13/07/19		30	0		DAS 08 9-89
Quality Control									
150	Identify as-per dwg & Stock Location: WAC01	0.00							
*150*									
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****					30x			17.12.13-07-19

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June-18-13 8:22:53 AM

**\*103163\***

Page 3

Item ID: D3204-11

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Plate

Start Date: 6/18/13 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*MUS 13-07-22*

*pl/B-07-19*

# Picklist Print

June-18-13 8:22:57 AM

Page 1

Work Order ID: 103163

\*103163\*

Parent Item: D3204-11

\*D3204-11\*

Parent Item Name: Plate

Start Date: 6/18/13

Required Date: 7/02/13

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM  
IPP Rev:D Now on Waterjet 08-01-08 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.375X01.00  
0

Purchased

No

100

f

42.3134

0.1063

~~2.336842~~

**\*M6061T6B0 375X01 000\***

6061T6 BAR .375 x 1.00

\*\*

3.5 -

Jm130302

Location

Loc Qty

Loc Code

MAT002

42.3134

124573

2.3134

125257

40

25257.

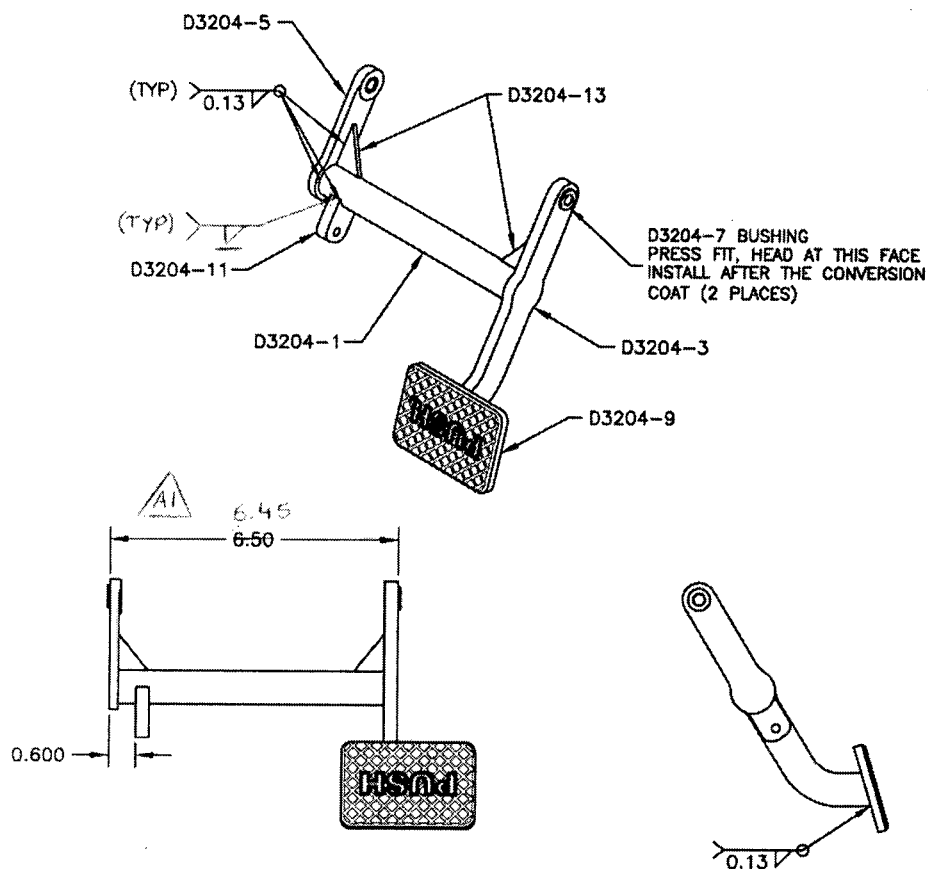






DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED  
1040430



### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

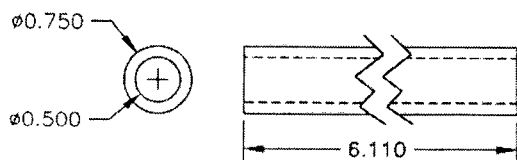
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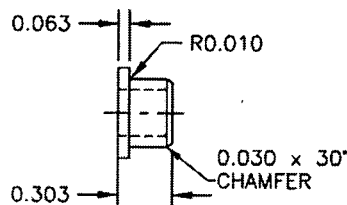


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

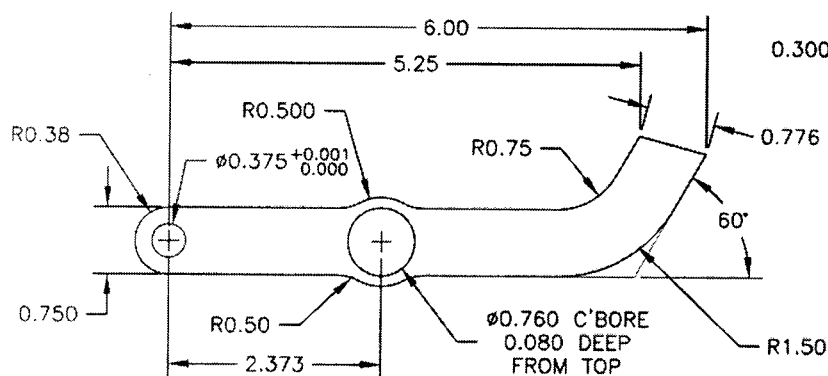
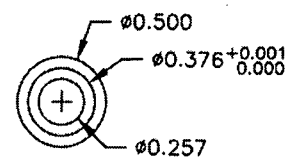
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04.04.05



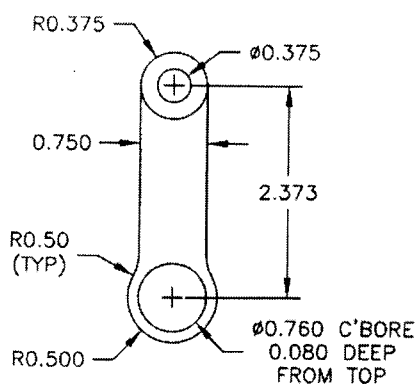
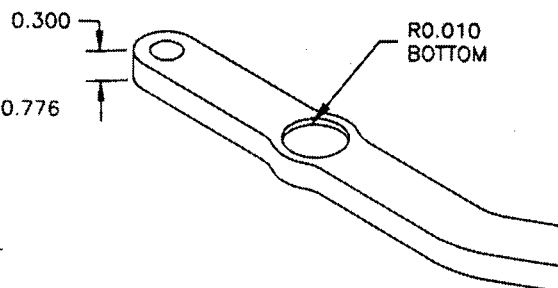
2 D3204-1 TUBE  
SCALE 1:2



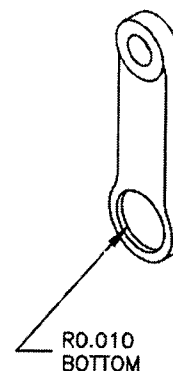
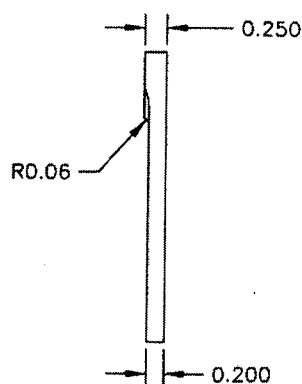
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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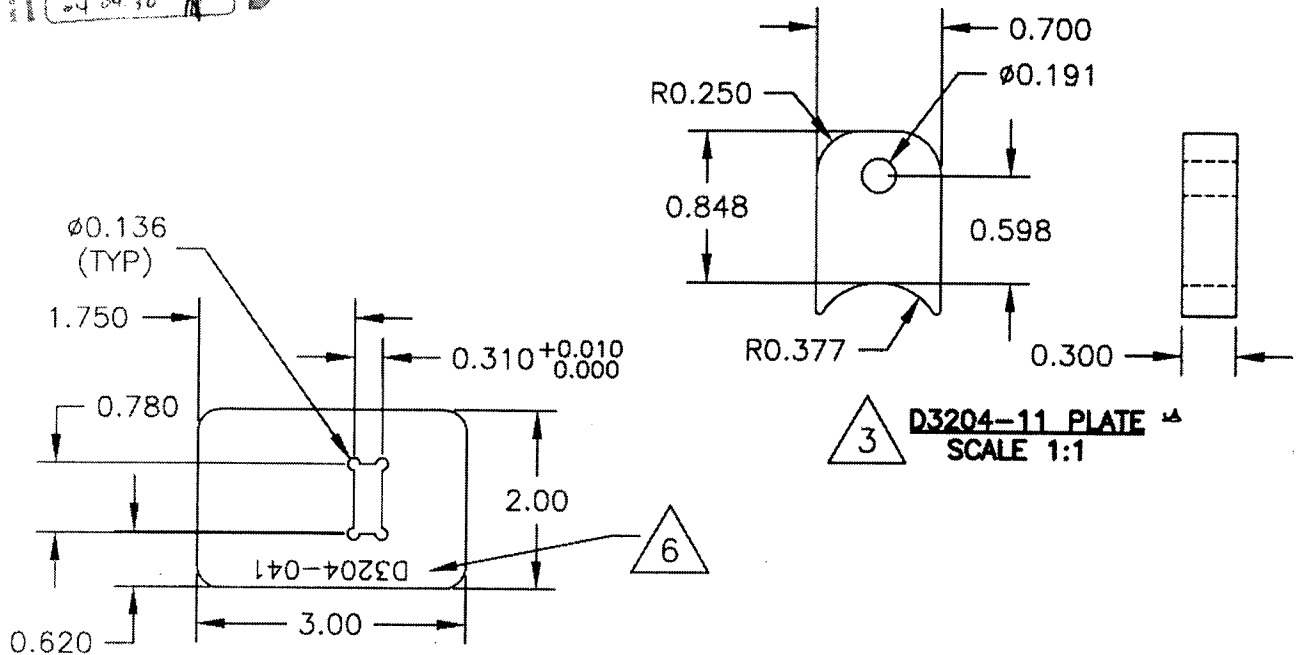
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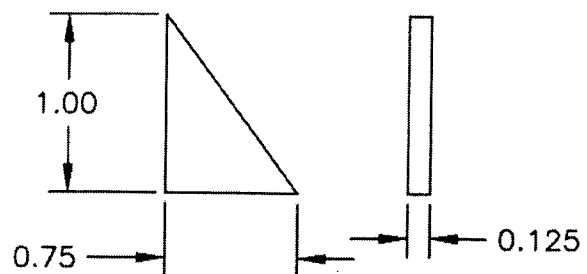
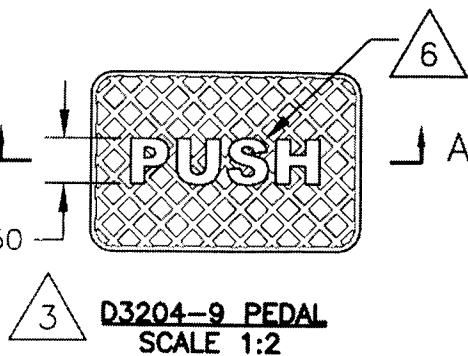
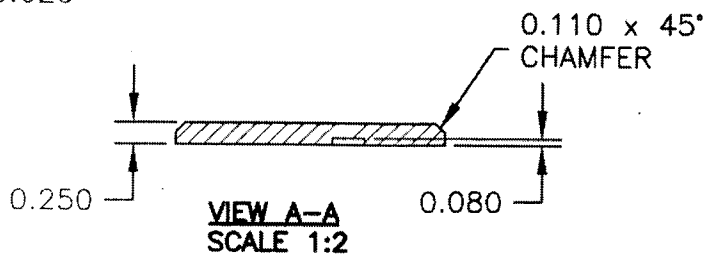


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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

RELEASED  
04.04.30



3 D3204-11 PLATE  
SCALE 1:1



5 D3204-13 GUSSET  
SCALE 1:1

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